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647.7710
Job Sheet 186273



Part No: 647.7710

Job Qty: 10 ea

Part Name: Strut Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/29/18	0.00	0.00	Start Up Machining-1		PROD 10-11-27
110	Mill Conv	10 pcs		11/29/18	0.00	1.80	Mill Conv 1		PROD 10-11-27
120	QC	10 pcs		11/29/18	0.00	0.00	QC2 Machining-1		PROD 10-11-27
125	QC	10 pcs		11/29/18	0.00	0.00	QC8 Machining-1		PROD 10-11-27
130	Packaging	10 pcs		11/29/18	0.00	0.00	Packaging3-1		PROD 10-11-27
140	QC21-SA	10 Ea		11/29/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 110 - 1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG
Descriptions: 130 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

NOV 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NT0.500W.083	4130 Round Tube .500 X .083W	8.2000 ft (.82 ea)	90-Start up Operation	5130961

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NT0.500W.083	8	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	9.750inches $\pm$ 0.005	9.755 9.745		
2	Strut Tube	0.500inches $\pm$ 0.005	0.505 0.495	Diameter	
3	Strut Tube	0.334inches $\pm$ 0.005	0.339 0.329	Diameter	
4	Strut Tube	0.188inches $\pm$ 0.005	0.193 0.183	Radius	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step _____		 Part: 647.7710 Job No: 186273 Serial No/Batch: S131842 Container No: S131842 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 11/27/18		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: center;">Engineering</td> <td style="width: 20px; height: 20px;"></td> </tr> <tr> <td style="text-align: center;">Quality</td> <td style="width: 20px; height: 20px;"></td> </tr> <tr> <td style="text-align: center;">Other</td> <td style="width: 20px; height: 20px;"></td> </tr> </table>		Engineering		Quality		Other	
Engineering											
Quality											
Other											
Description Work Order		MRB (QSI042) Approval									
		Completed By									
		Lead hand / Supervisor Approval Verification									
		QC / QA Coordinator Approval									

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				